

Work Order ID 128850

128850

Page 1

Tuesday, February 24, 2015 12:59:16 PM

Item ID: D412-705-017

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: N1 Gearbox Access Panel

Start Date: 1/20/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/26/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 15-02-24

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3255	Rev B								
IIN-D412-705	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-705-017		CHG001						
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

DAS
27
9-89

DAS
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2

MAR 02 2015

2X

FEB 24 2015

DAS
28
9-89

Work Order ID 128850

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Tuesday, February 24, 2015 12:59:16 PM

Item ID: D412-705-017

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: N1 Gearbox Access Panel

Start Date: 1/20/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/26/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-705-017 Location: <u>floor</u> PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
06
9-89

2

MAR 02 2015

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06
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2

MAR 02 2015

ML5 150304

3.3

Picklist Print

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Work Order ID: 128850

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Parent Item: D412-705-017

D412-705-017

Parent Item Name: N1 Gearbox Access Panel

Start Date: 1/20/2015

Required Date: 1/26/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C Removed Manufacturing 06-08-02 JLM
IPP Rev:D ECN 1052 07-11-06 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C3A		Purchased	No			110	Each	77.0000	30	60			
AN3C3A									**			DAS 27 9-89	DAS 28 9-89
Bolt													

DAS
06
9-89

Location Loc Qty Loc Code

GA	21	
124417	21	
ST350	56	
1131618	56	

D3255-041		Manufactured	No			110	Each	2.0000		2			
D3255-041									**			DAS 27 9-89	DAS 28 9-89
Access Panel Assy													

DAS
06
9-89

Location Loc Qty Loc Code

ST495	2	
111539	2	

D3255-042		Manufactured	No			110	Each	4.0000		2			
D3255-042									**			DAS 27 9-89	DAS 28 9-89
Access Panel Assembly													

DAS
06
9-89

Location Loc Qty Loc Code

ST498A	4	
106054	4	

Picklist Print

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Work Order ID: 128850

Parent Item: D412-705-017

Parent Item Name: N1 Gearbox Access Panel

128850

D412-705-017

Start Date: 1/20/2015

Required Date: 1/26/2015

Start Qty: 2.00

Required Qty: 2.00

MS20427M3-3

Purchased

No

110

Each

853.0000

36

72

**

DAS
27
9-89
FEB 24 2015

MS20427M3-3
Rivet

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

207

m129864

7

m130922

200

ST311

646

646

m130922

110

Each

201.0000

18

36

**

DAS
27
9-89
FEB 24 2015

MS21060-L3K

Purchased

No

MS21060-L3K
Nut Plate

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

100

m131467

100

ST302

101

101

m131187

110

Each

187.0000

30

60

**

DAS
27
9-89
FEB 24 2015

MS9321-09

Purchased

No

MS9321-09
Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST273

187

m131187

187

DAS
27
9-89

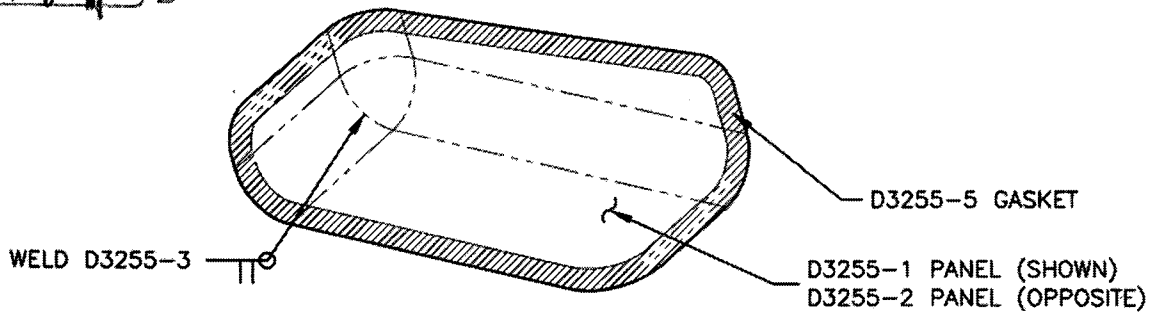
Tuesday, February 24, 2015 12:59:21 PM

Shop Packet Print

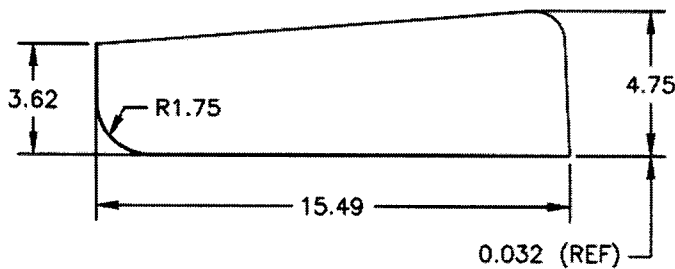
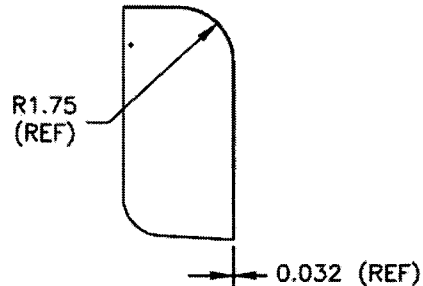
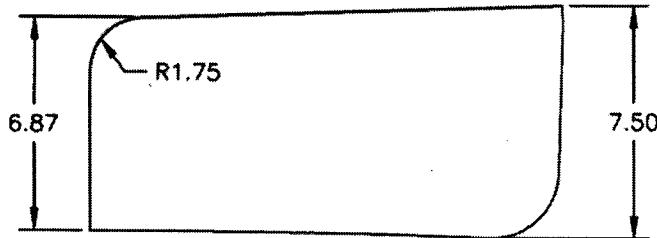
Page 2

DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05.01.18 #

D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

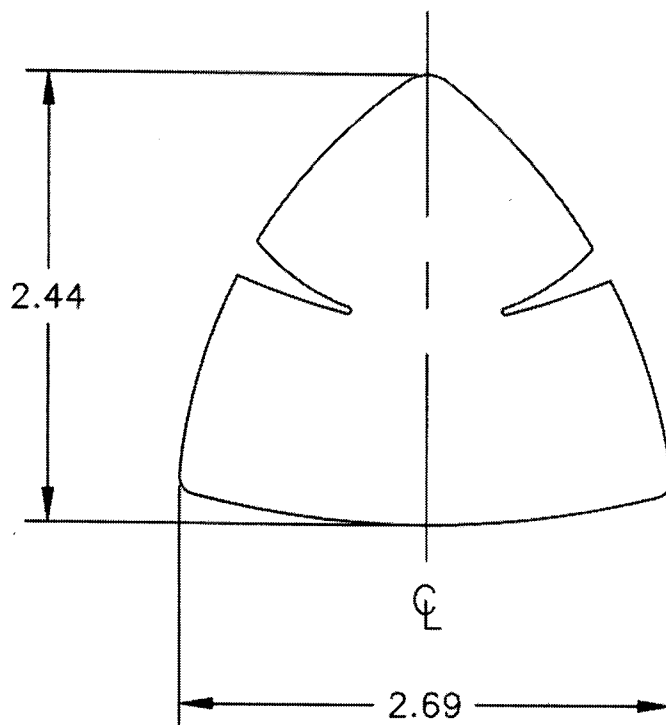
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128850 M.L.S
05-01-29

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED qp	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05-01-18 [Signature]

D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

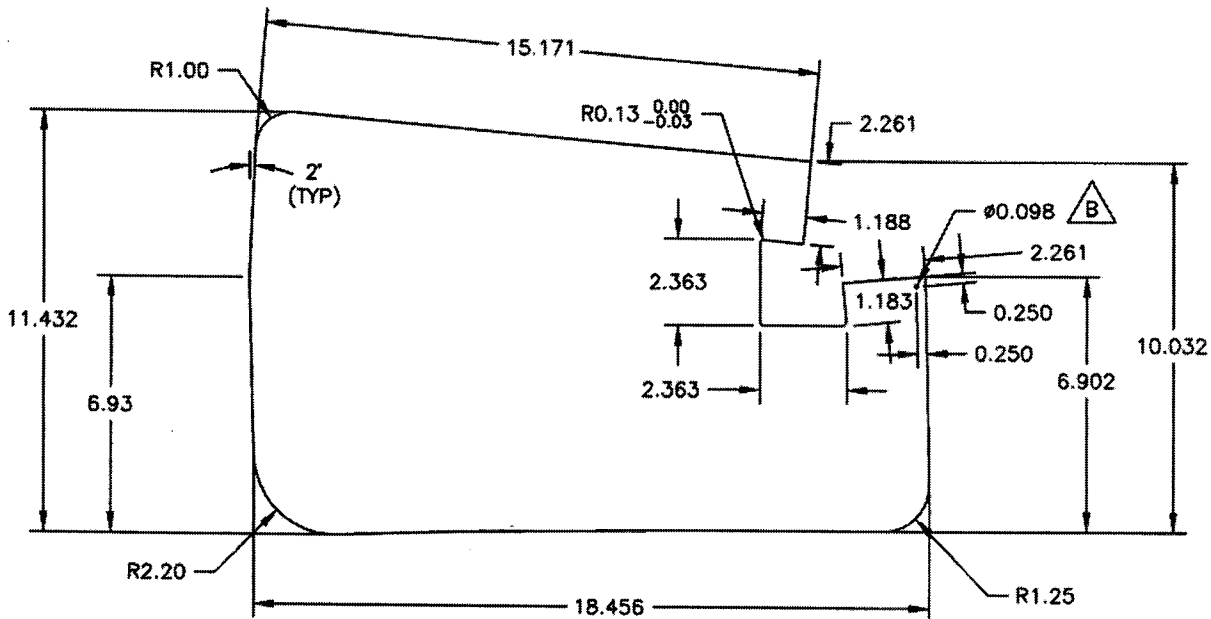
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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DART

DESIGN RT	DRAWN BY DT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18**D3255-1/-2 FLAT PATTERN****D3255-1/-2 NOTES:**

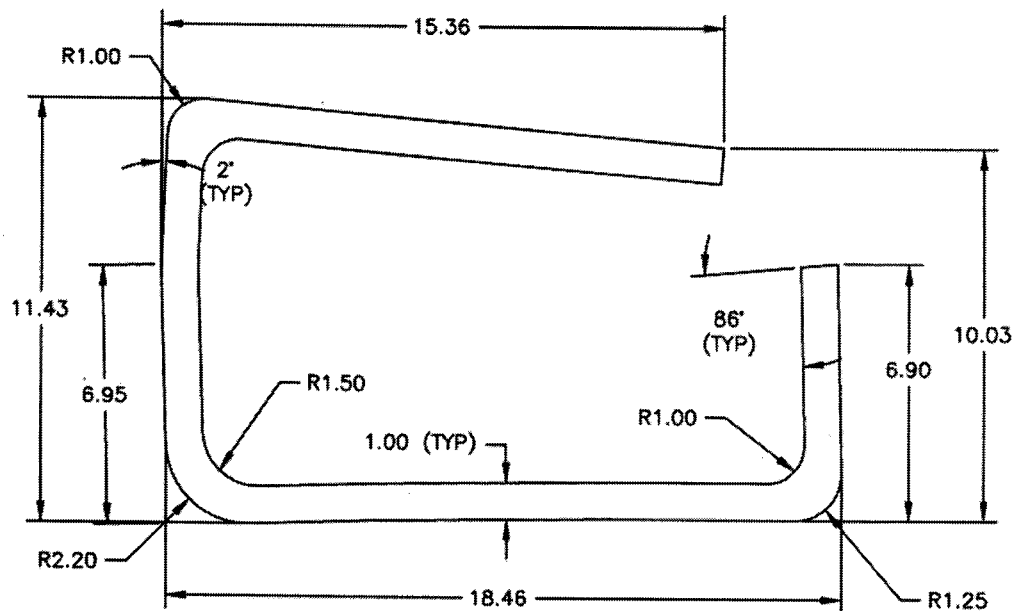
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART

DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05.01.18**D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
	2						D3245-9	GASKET
	2						D3245-11	GASKET
	2						D3245-13	GASKET
							D3255-041	ACCESS PANEL ASSEMBLY, LH
							D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-1	ACCESS PANEL
		1					D3256-3	GASKET
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	30		6		AN3C-3A	BOLT
		3					AN3C-4A	BOLT
						30	AN960JD10	WASHER
	16	44	36		12		MS20427M3-3	RIVET
						2	MS21051-L3K	NUT PLATE
	8	22	18		6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
		25	30		6		MS9321-09	WASHER

Work Order ID 128850

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Item ID: D412-705-017

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: NI Gearbox Access Panel

Start Date: 1/20/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/26/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *MLG*Date: *15-02-24*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3255

Rev B

IIN-D412-705

E

DAS
27
*8:59**MLG 15-02-24*
(2)

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-705-017

CHG001

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
27
8:59
FEB 24 2015